

Work Order ID 92563

November-01-12 1:24:36 PM

92563

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Item ID: D3278-2 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Support
 Start Date: 11/01/12 Start Qty: 60.00 *60* Cust Item ID:
 Required Date: 11/30/12 Req'd Qty: 60.00 *60* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	B.A	12/11/18		60	0		DAS 08 9-89
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				60	0	12/11/19	
150 *150* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo START TIME: 1:00 FINISH TIME: 3:20	0.00 0.00				60	0	12/11/20	MJ

M122878

3200F

1:30

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Item ID: D3278-2

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Support

Start Date: 11/01/12 Start Qty: 60.00

60

Cust Item ID:

Required Date: 11/30/12 Req'd Qty: 60.00

60

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

60x 4 11/11/20

170

Identify as per dwg & Stock Location: GA

0.00

170

Packaging

Memo

0.00

Packaging

01/11/21

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

12/11/22

ME 12-11-21

Picklist Print

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Work Order ID: 92563

Parent Item: D3278-2

Start Date: 11/01/12

Required Date: 11/30/12

Parent Item Name: Support

Start Qty: 60.00

Required Qty: 60.00

Comments: IPP: A04.04.19New issueKJ/JLM
IPP B 07.09.06 Rev C dwg EC Verified by: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.000X02.000 6061-T6 Bar 1.00 x 2.00		Purchased	No			100	f	41.4192	0.2337	14.76			

Location	Loc Qty	Loc Code
MAT	6.6292	
112567	0	
121660	6.6292	
MAT004	34.79	
→ 122081	10.79	
→ 123279	24	

PO 12/11/05

7.38
7.38

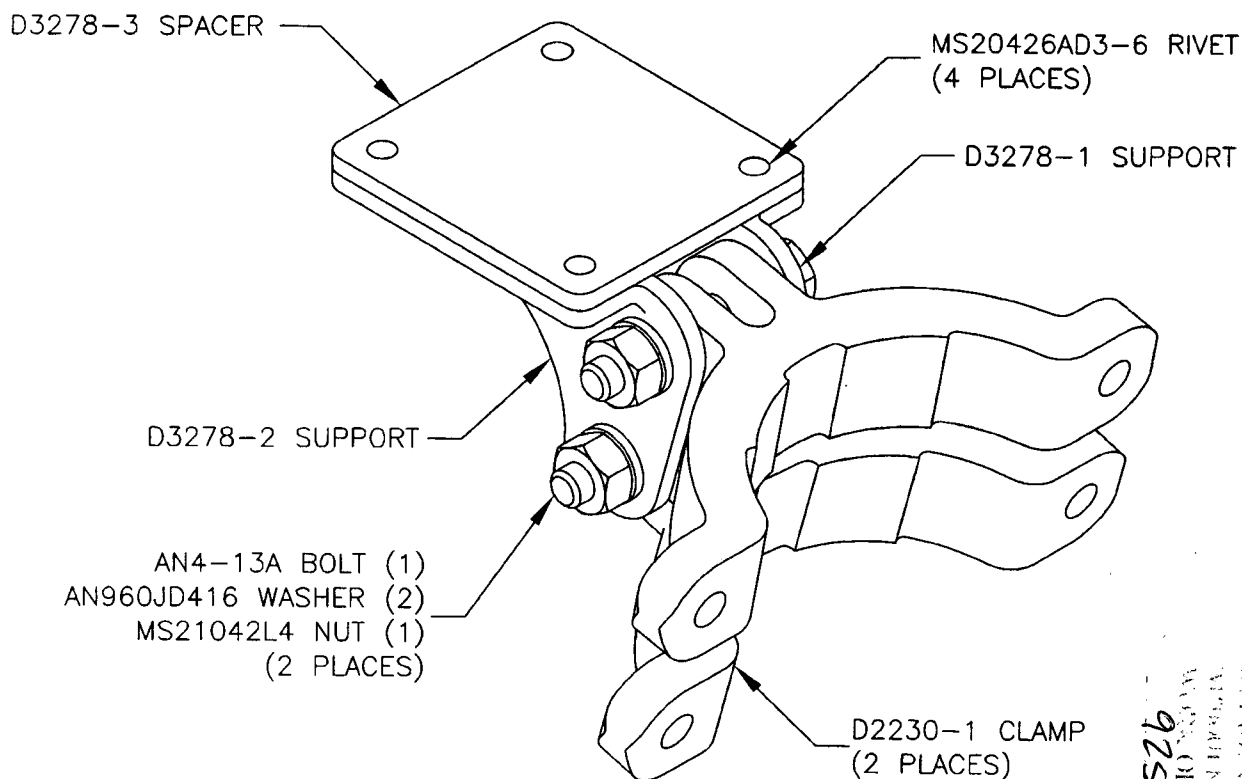
END of BATCH

DART

DESIGN <i>GP</i>	DRAWN BY <i>BC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. D3278	REV. C SHEET 1 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE NTS
A	04.03.03	NEW ISSUE	
B	05.03.31	CHANGE DIM/TOL TO ENSURE FIT	
C	07.07.24	CHANGED RIVETS PER PAR #185	

RELEASED
07-08-06

D3278-041 SUPPORT ASSEMBLY



Qty	Part Number	Description
X	D3278-041	SUPPORT ASSEMBLY
2	D2230-1	CLAMP
1	D3278-1	SUPPORT
1	D3278-2	SUPPORT
1	D3278-3	SPACER
2	AN4-13A	BOLT
4	AN960JD416	WASHER
4	MS20426AD3-6	RIVET
2	MS21042L4	NUT

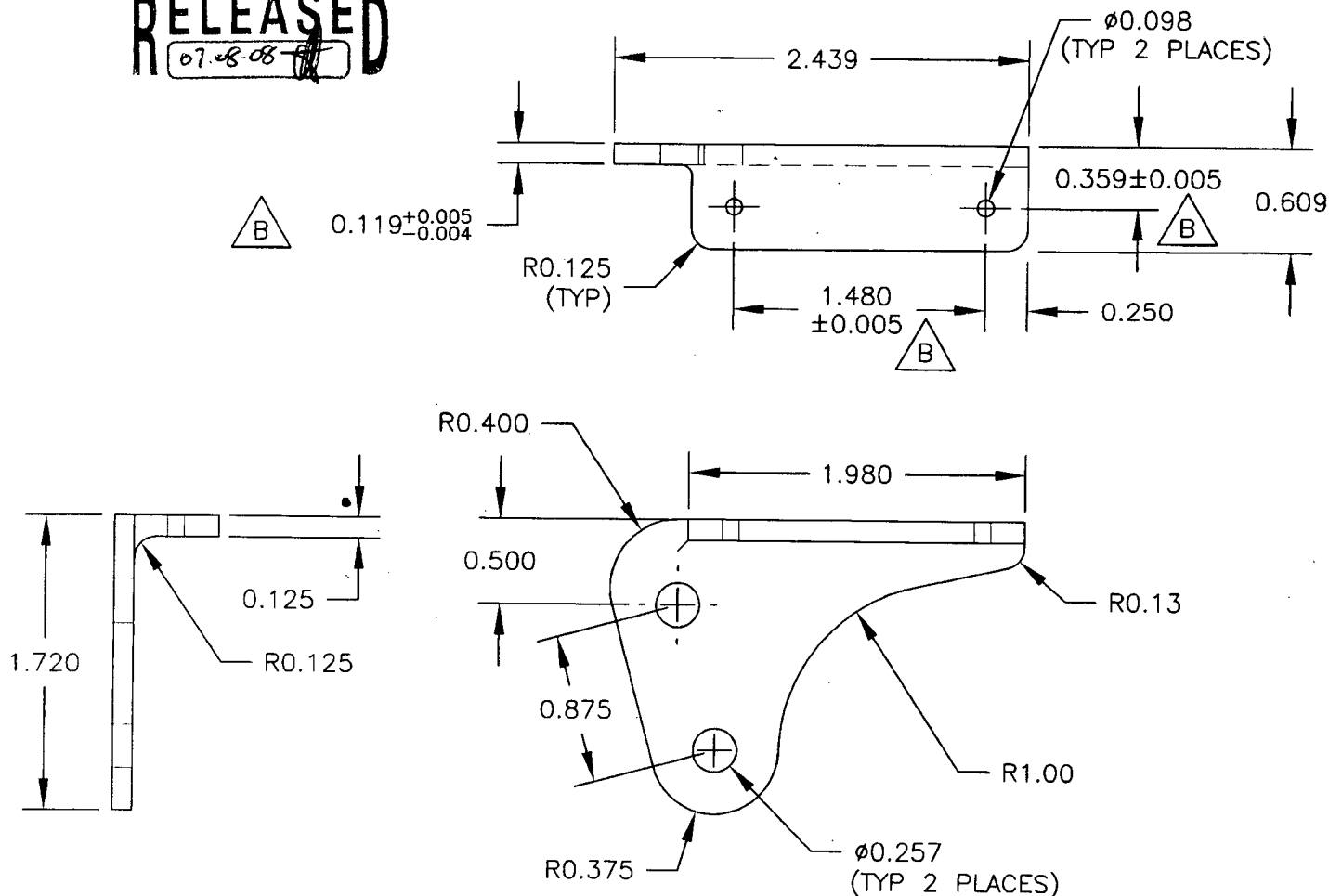
Copy to
DART AEROSPACE LTD
HAWKESBURY, ONTARIO
CANADA
FOR APPROVAL
AND SIGNATURE
DATE
12-11-01
92563 M5

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DESIGN 9P1	DRAWN BY BC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED B	APPROVED H	DRAWING NO. D3278	REV. C SHEET 2 OF 3
DATE 07.07.24	TITLE SUPPORT ASSEMBLY		SCALE 1:1

RELEASED
07.08.08**D3278-1 SUPPORT (SHOWN)****D3278-2 SUPPORT (OPPOSITE)**

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

92563

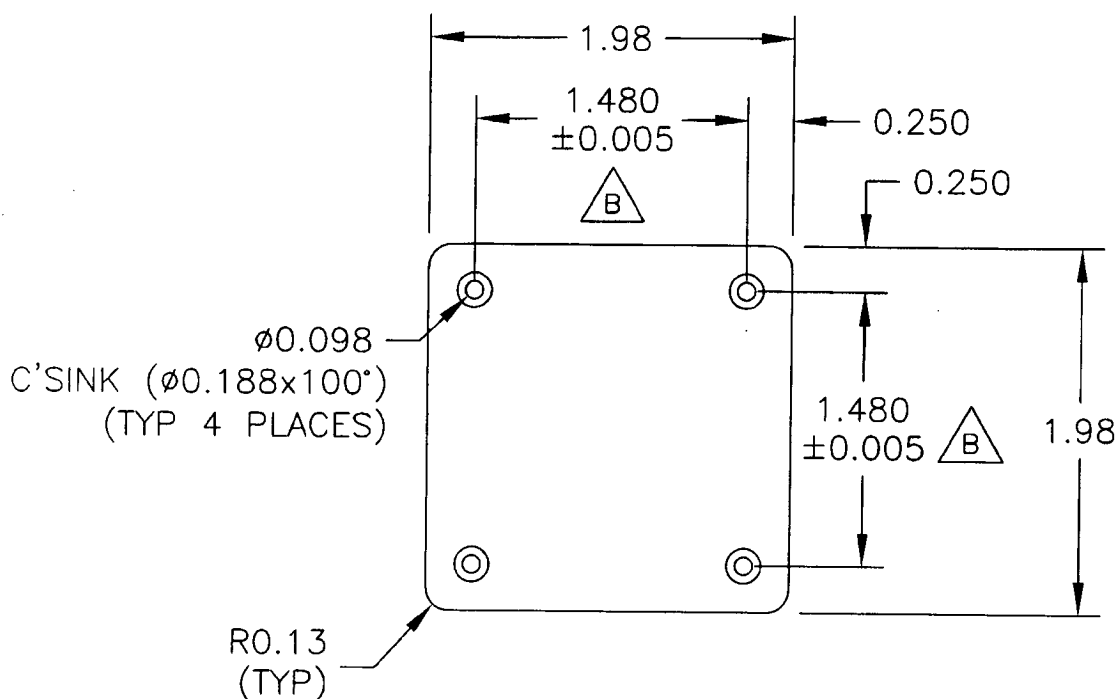
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DESIGN <i>GP</i>	DRAWN BY <i>BC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3278	REV. C SHEET 3 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE 1:1

RELEASED
07.08.08



D3278-3 SPACER

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-B0.125x2.000) OR
DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-S.125)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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DART AEROSPACE LTD		Work Order:	92563
Description: Support		Part Number:	D3278-2
Inspection Dwg: D3278	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.005/-0.000	.098	—			
0.359	+/-0.005	.359	—			
0.609	+/-0.010	.614	—			
0.250	+/-0.010	.250	—			
1.480	+/-0.005	1.480	—			
R0.125	+/-0.010	.125	—			
0.119	+0.005/-0.004	.121	—			
2.439	+/-0.010	2.442	—			
1.980	+/-0.010	1.979	—			
R0.13	+/-0.030	.130	—			
Ø0.257	+0.005/-0.000	.258	—			
R0.375	+/-0.010	.375	—			
0.875	+/-0.010	.873	—			
0.500	+/-0.010	.502	—			
R0.400	+/-0.010	.400	—			
R1.00	+/-0.030	1.000	—			
1.720	+/-0.010	1.722	—			
R0.125	+/-0.010	.125	—			
0.125	+/-0.010	.127	—			
			—			

Measured by:	<i>DAS</i> 02 9-83
Date:	12-11-16

Audited by:	<i>DAS</i> 08 9-83
Date:	12/11/16

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.19	New Issue P/O D3278-041	KJ/JLM	
B	05.06.08	0.359 was 0.365; 0.119 was 0.125	KJ/JLM	
C	07.09.26	Dimensions updated per Dwg Rev. C	KJ/EC	<i>JE</i>